

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 36421		
Estimate Number	: 12884		
P.O. Number	:		
This Issue	: 12/18/2007 S.O. No. :	Part Number	: D3560044
Prsht Rev.	: NC	Drawing Number	: D3560 UNDER REVIEW
First Issue	: 11	Project Number	: N/A
Previous Run	: 35406	Drawing Revision	: 0 D
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 1/10/2008
Comment	: Est Rev A New Issue 07.05.24 EC	Qty:	10 Um: Each
	: Est Rev B ECN 987 07.10.09 EC verified by DD		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar 50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M106747

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev. AA & Dwg D3560 Rev. D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36421

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
PLATE

3.35331 ✓

08-07-10

SP (4X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

### STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch ( 65 deg C ) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP

08-07-10 (4X)





Date: Tuesday, 12/18/2007 10:51:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36421

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/01 (4)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch: B35330

EF 08/07/14

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EF 08/07/14 (4)  
S 08/07/14 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT E.

SS 08/07/14 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/15

Job Completion



mf 08-07-14











D3592-1 PLATE

D3560-1 ARM

D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D3560-041 ARM WELDMENT

D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D3560-2 ARM

D3592-1 PLATE

D3560-042 ARM WELDMENT

D3592-1 PLATE

D3560-3 ARM

D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D3560-043 ARM WELDMENT

D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D3560-4 ARM

D3592-1 PLATE

D3560-044 ARM WELDMENT

DETAIL A  
SCALE 1:2

(REF)

ARM  
(REF)

1.705

PLATE  
(REF)

1.705

ARM  
(REF)

(REF)

DETAIL B  
SCALE 1:2

## PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1	1			D3560-1	ARM
		1		D3560-2	ARM
		1		D3560-3	ARM
1	1	1	1	D3560-4	ARM
				D3592-1	PLATE

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## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS
C	REMOVE POWDER COAT
B	REDESIGN AS WELDMENT, ADD POCKETS
A	NEW ISSUE

REV.	DESCRIPTION
DESIGN	
DRAWN	lpc
CHECKED	5
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	07.11.16

DART AEROSPACE  
HAWKESBURY, ONTDRAWING NO.  
D3560TITLE  
ARM WELDMENTCOPYRIGHT © 2006 BY DART AEROSPACE  
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07.12.16

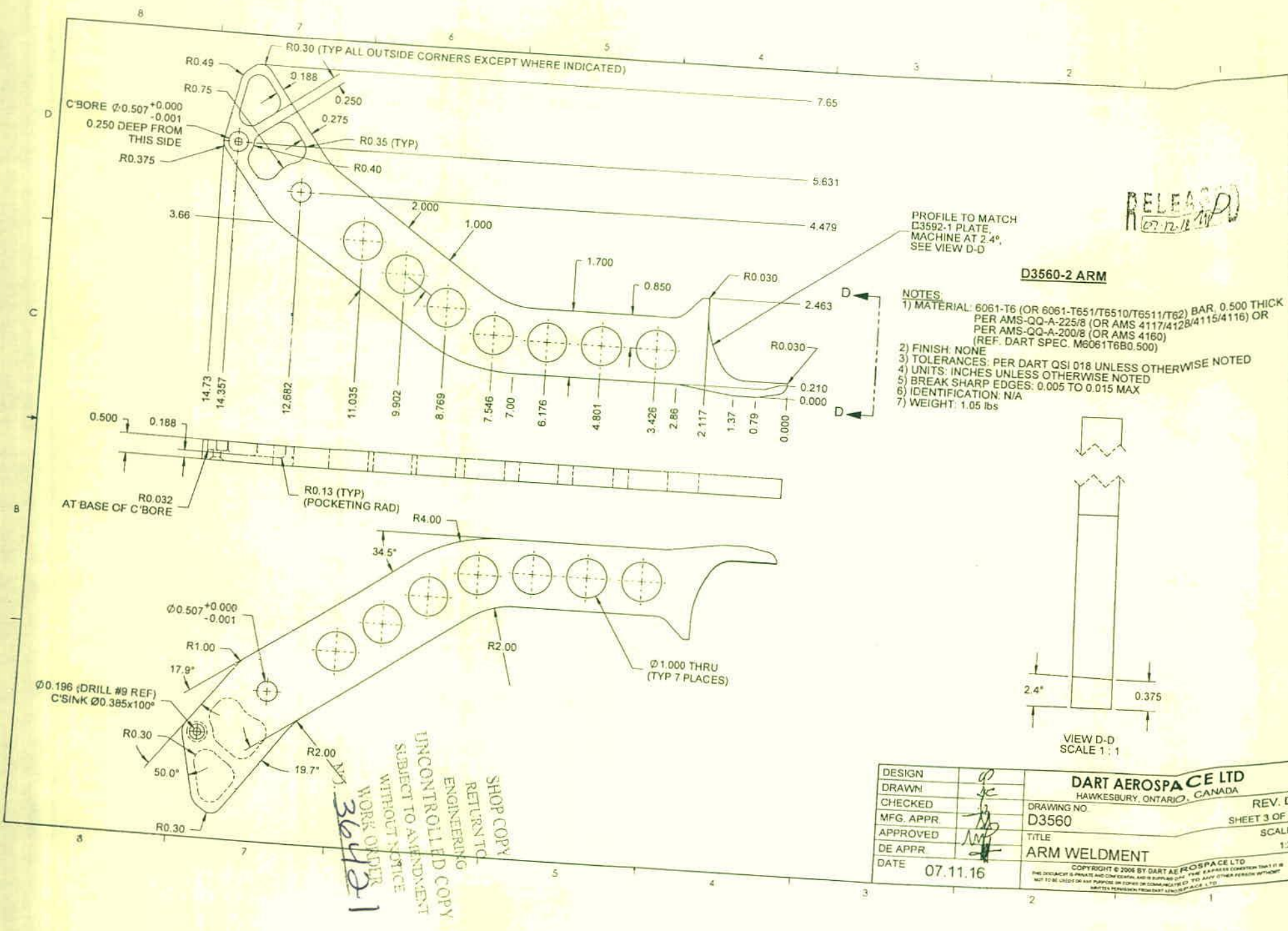








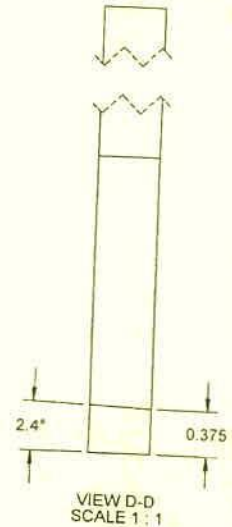




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07-12-16

### D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



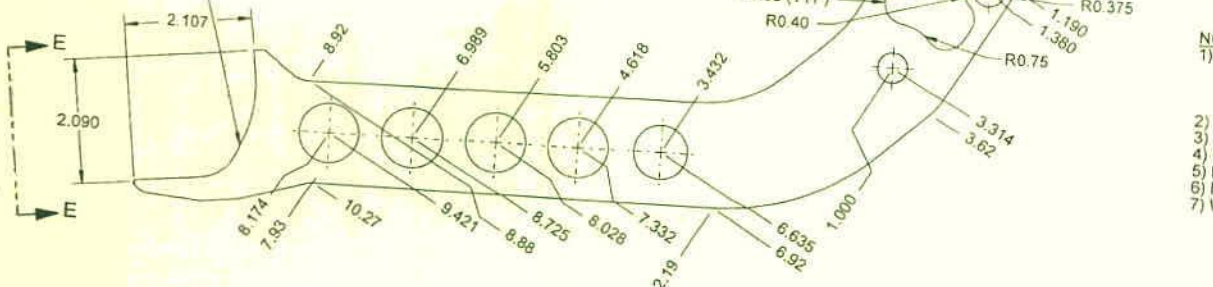
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	SHEET 3 OF 5
MFG. APPR.		D3560	
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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3642-1





PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



### D3560-3 ARM

#### NOTES

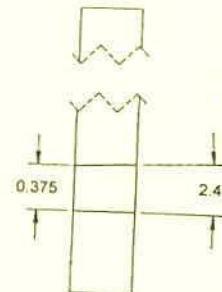
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

R0.13 (TYP)  
(POCKETING RAD)

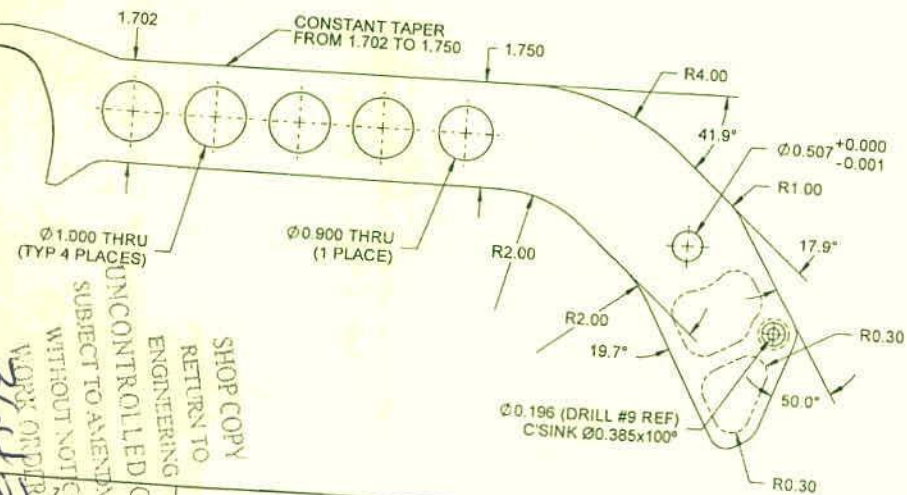
0.188

0.500

R0.032  
AT BASE OF C'BORE



VIEW E-E  
SCALE 1:1



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DRAWN	AC		
CHECKED	AC		
MFG. APPR.	AC		
APPROVED	AC		
DE APPR.	AC	DRAWING NO. D3560	TITLE ARM WELDMENT
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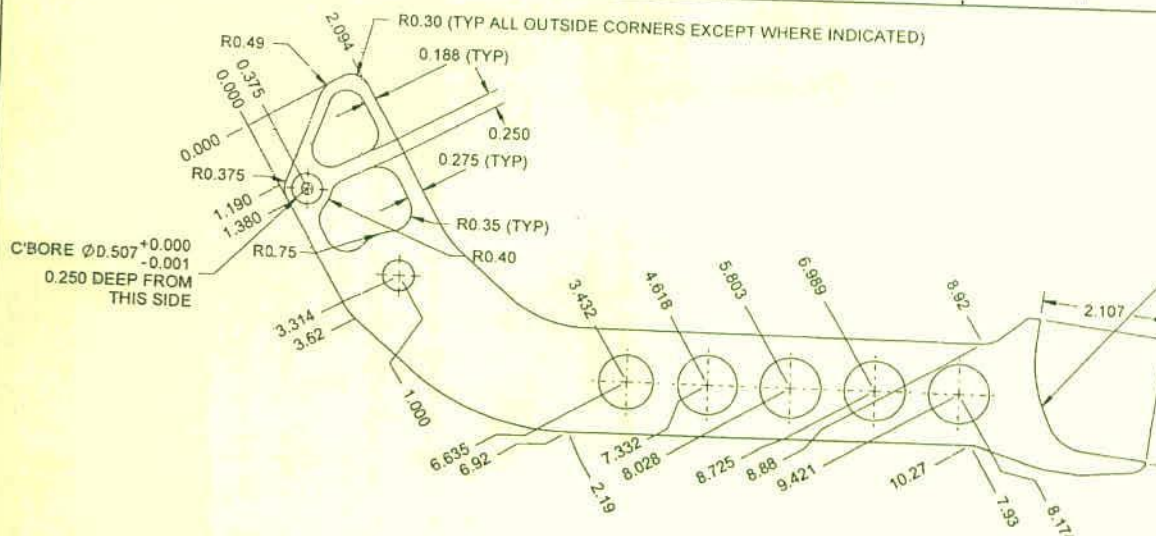
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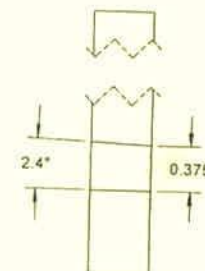
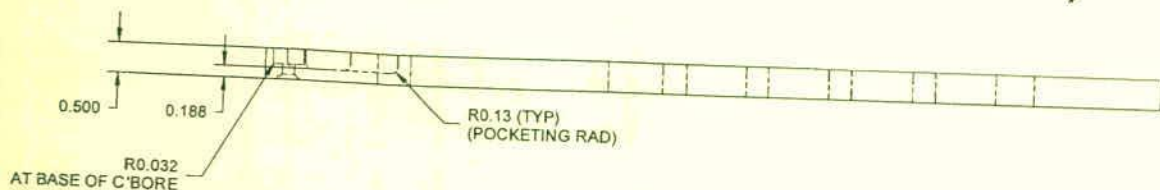


PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW F-F

### D3560-4 ARM

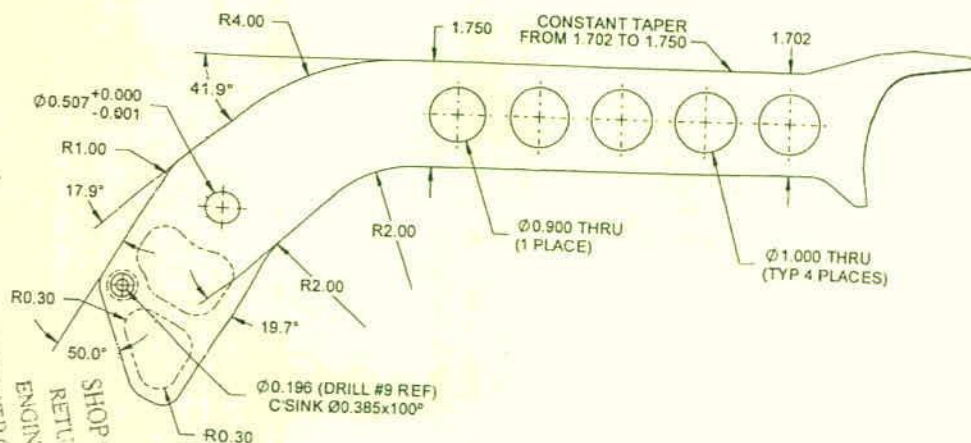
#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F  
SCALE 1:1

FILE  
10-12-16



DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
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APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	ARM WELDMENT	1:1
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